

Date: Tuesday, 4/18/2006 10:02:36 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 26670		
Estimate Number	: 11375		
P.O. Number	: N/A	Part Number	: D33871
This Issue	: 4/18/2006 S.O. No. : N/A	Drawing Number	: D3387 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 26651	Material	: N/A
Written By	: <u>See LA COMMENT Below</u>	Due Date	: 5/2/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>06.04.18</u>		
Comment	: Est:A 05.06.10 New Issue KJ/JLM : Est:B 06.03.22 Split c'sink op. EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
-----	--------------------	-------------------------



Comment: Qty.: 1.5685 f(s)/Unit Total: 15.6849 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6/T651 (QQ-A-200/8)
 (M6061T6B0.500x06.000)
 Identify for D3387-1
 Batch: M100742 7PCS M18463 3PCS JE 06/04/28 10

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank: 6.000" x 0.500" x 17.800" long

J.F. 06/04/28 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA511 and Dwg D3387
 Identify as D3387-1
 Tumble and Deburr NO sharp edges

mf 06/04/29 10

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 C'sink Ø0.375" as per Dwg D3387

mf 06/04/29 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/05/0
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:02:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 26670

Part Number: D33871

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 06/04/29

10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.I 06/04/29

10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA30*

PE 06.05.01

10

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/05/01

10

Job Completion



W060501

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26670
Description: Arm		Part Number:	D3387-1
Inspection Dwg: D3387	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	+/-0.010	R .125"	—			
0.125	+0.020/-0.000	.125"	—			
Ø0.375 x100°	+/-0.010	Ø0.380 x100°	—			
R0.032	+/-0.010	R .032"	—			
0.500	+/-0.010	.500"	—			
0.500	+/-0.010	.500"	—			
7.577	+/-0.010	7.578"	—			
R0.125	+/-0.010	R .125"	—			
Ø0.507	+0.000/-0.001	Ø .506"	—			
0.250	+/-0.010	.250	—			
1.347	+/-0.010	1.347"	—			
2.000	+/-0.010	2.004"	—			
1.000	+/-0.010	1.003"	—			
Ø0.191	+0.005/-0.000	Ø .191"	—			
R0.300	+/-0.010	R .300"	—			
2.033	+/-0.010	2.036"	—			
0.280	+/-0.010	1.703				cant find the measured
0.222	+/-0.010					cant find the measured
1.700	+/-0.010	1.703"	—			

Measured by: J.F.	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 06/04/28	Date: 06/04/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.01.18	DRAWING NO. D3387	REV. A
	TITLE ARM	SHEET 1 OF 1
A	05.01.18	NEW ISSUE
		SCALE 1:3

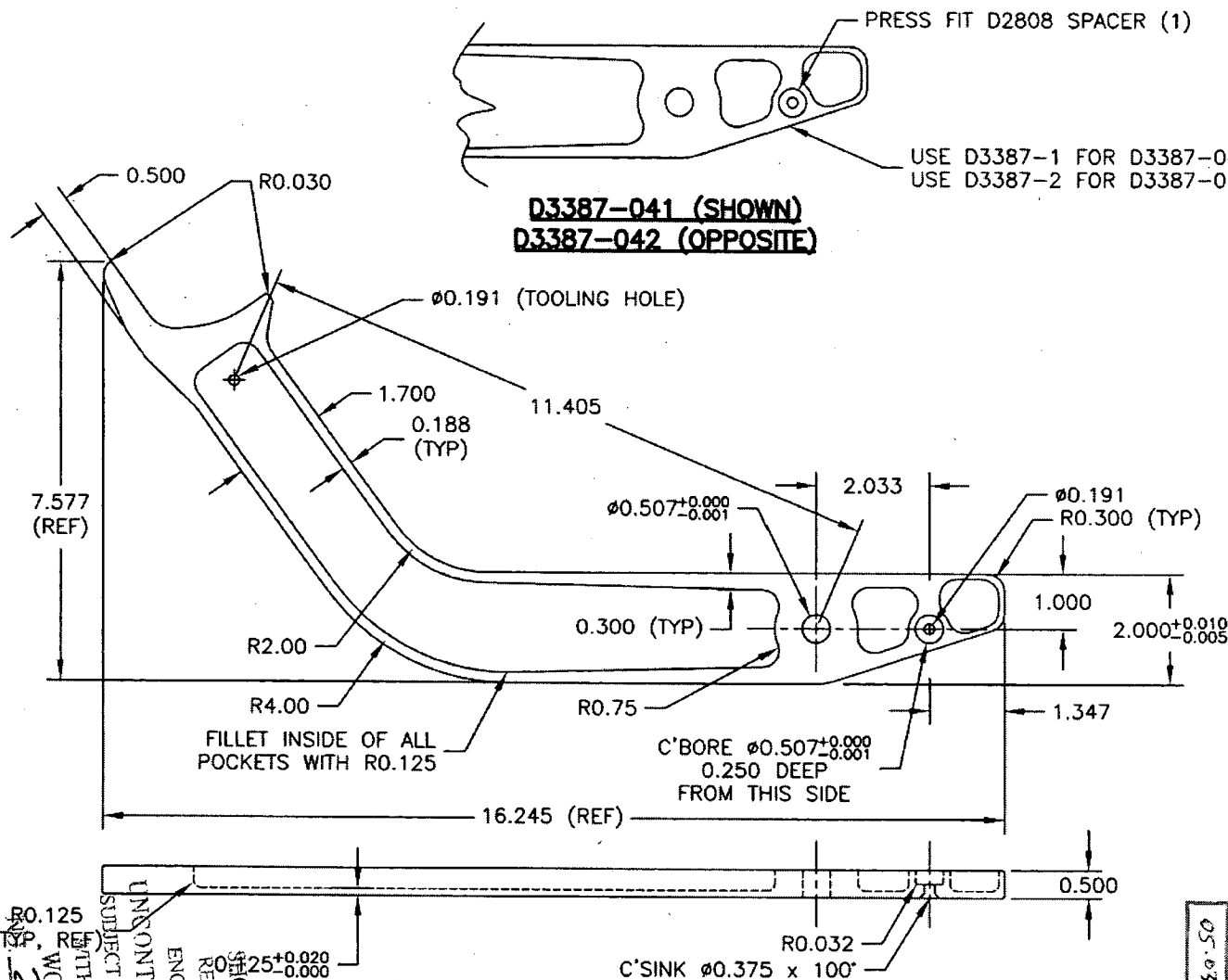
RELEASED

05.03.11

PRESS FIT D2808 SPACER (1)

USE D3387-1 FOR D3387-041
USE D3387-2 FOR D3387-042

D3387-041 (SHOWN)
D3387-042 (OPPOSITE)



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

- MACHINE PER DRAWING FILE "D3387-A.DWG"
- MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK
(REF DART SPEC. M6061T6B0.500)
- DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
STOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE

0.125
OR WORK ORDER
26670